DART AEROSPACE LTD				Work Order:	2B354 -A	
Description:				**Part Number:**	D2803/04 AB	
Dwg:	Re-machine per Rev. B				D2803.1	
				Qty:		
					Page of	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
1		Re-machine D2804 brackets $\cancel{to}$ AS per	SA	06.01.15	
		Dwg D2804 Rev B:			
		D2804-1 B14241 Qty 2	SA	06.01.15	2
		D2804-2 B14242 Qty 10	SA	06.01.15	9 PTO
2	QC2	Inspect parts As they come off of CNC	SA	06.01.15	9
3	QC7	second Inspection check	JSG	06.01.16	9/2
4	FP	Touch-up Alodine AS required.	CL	06/01/16	9/2
5	QC5	Inspect work			
6	St.	Identify and stock with batch #			
		indicated on W/O.			
7	AC	cost.			
8	DC/QC21	close W/O			
4b	GA	For 2 parts: Press D2805-2 into	SD	06/01/16	2
		arm per drwg ~~D2803~~/D2804			
		D2804 ~~-#~~ B B14241			
		D2805-1 ~~B B23628~~ B23628			
4c	QC	Inspect level 5	AC	06.06.16	2
4d	FP	Powder coat Gloss white	M	06 01 17	9/2
4e	QC3	Inspect Powder coat	SB	06/01/25	
4f	GA	Press D2809 B ___ into arm per drwg D2804			

Rev	Date	Change	Revised By	Approved
4G	GA	follow attached w/o from step 7		

INSPECTION level 2l

SD 06/01/25

06.01.15 | 1 part pressed in D2804
hit by endmill.

DART

DESIGN CP	DRAWN BY CP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. D2804		REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & −043/−044		

RELEASED

05.03.11

$\varnothing 0.757^{+0.005}_{-0.000}$ (2 PLACES)

R0.625

0.500

0.125

0.125

R0.125 (TYP)

SECTION B−B
SCALE 2:3
(ROTATED)

$0.875^{+0.000}_{-0.001}$

0.250

$0.250^{+0.000}_{-0.005}$

0.125

R0.062 (TYP)

R0.125 (TYP)

SECTION A−A
SCALE 2:3
(ROTATED)

$0.608^{+0.000}_{-0.001}$

$\varnothing 0.191^{+0.005}_{-0.000}$ (2 PLACES)

12.304

1.420±0.001

R0.30

R0.625

$\varnothing 0.507^{+0.000}_{-0.001}$ C'BORE 0.250 DEEP

$2.654^{+0.000}_{-0.001}$

R1.000

$\varnothing 0.191^{+0.005}_{-0.000}$

$0.437^{+0.000}_{-0.001}$

6.933

$\varnothing 0.507^{+0.000}_{-0.001}$

R0.300 (TYP)

7.578
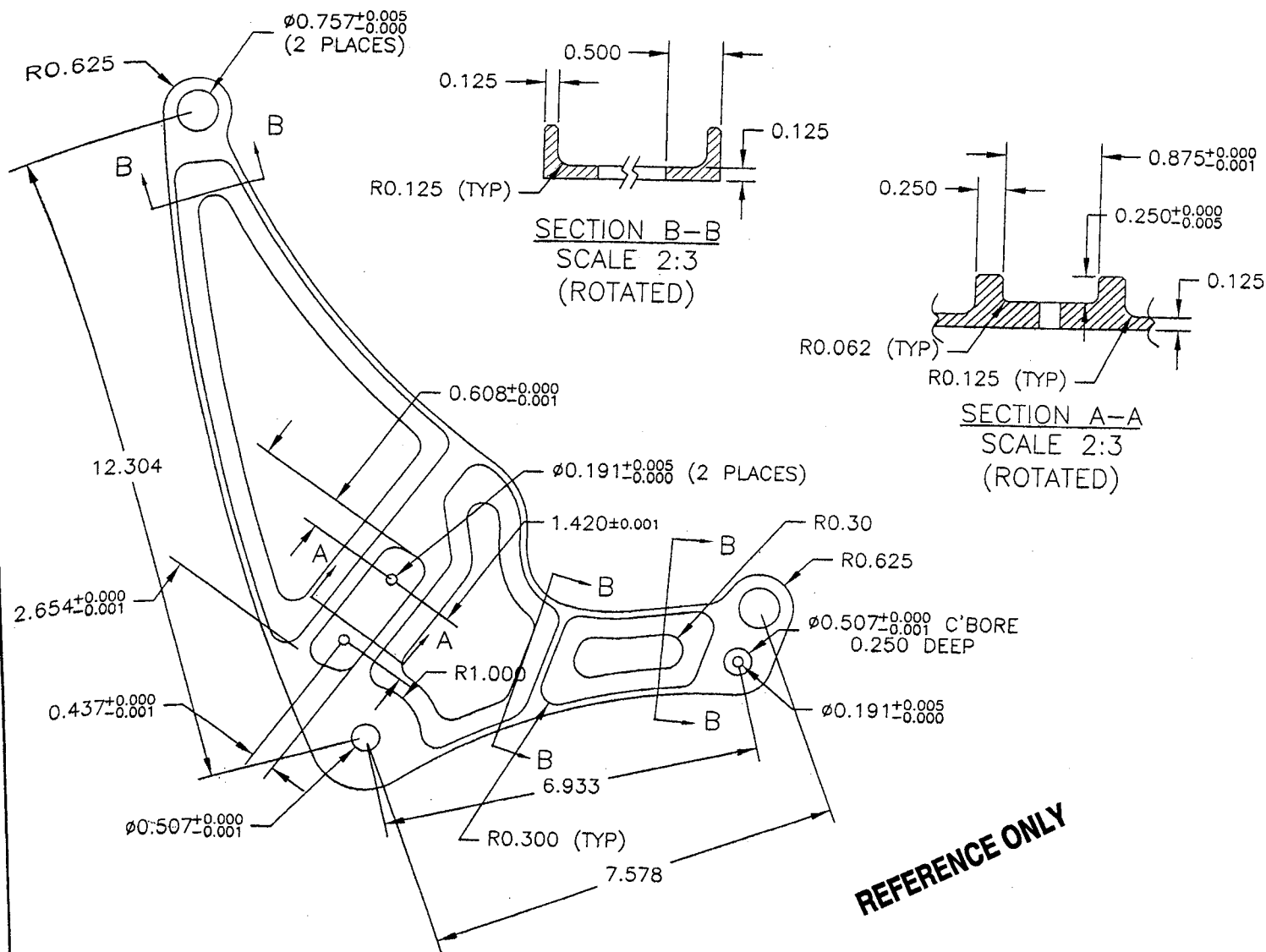
REFERENCE ONLY

D2804−1 BRACKET (SHOWN), D2804−2 BRACKET (OPPOSITE)

1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
2) MATERIAL: 6061−T6 (QQ−A−200/8) OR (QQ−A−250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 − 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Date: Monday, 11/21/2005 3:33:33 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	**Drawing Name**	: D2804
Job Number	: 24354		
Estimate Number	: 10804		
P.O. Number	:	**Part Number**	: D28031
This Issue	: 11/21/2005 S.O. No. :	**Drawing Number**	: Z_CUSTOM
Prsht Rev.	: NC	**Project Number**	:
First Issue	: / / Type :	**Drawing Revision**	:
Previous Run	: 00015	**Material**	:
Written By	: _____	**Due Date**	: 11/28/2005 Qty: 1 Um: Each
Checked & Approved By	: _____		
Comment	:		

Additional Product

Job Number: |||||||||||||||||||

Seq. #:	Machine Or Operation:	Description :
1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
REMACHINE PER REV. B D2803/D2804   *SA 06.01.15*

| 2.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |

Comment: INSPECT PARTS AS THEY COME OFF MACHINE   *SA 06.01.15*

| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |

Comment: INSPECT WORK TO CURRENT STEP   *BG 06.01.16*

| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1
BAG & TAG

| 5.0 | DC | DOCUMENT CONTROL |

Comment: DOCUMENT CONTROL

Job Completion |||||||||||||||||||

Dart Aerospace Ltd.   Nov 08, 2005
Hawkesbury   11:44 am

Work Order No	: 0024354		
Project Name	: D2803/D2804	Department Code:	
Project For	:	Burden Flags	: NNNNNNN
Work Order Type	: Main	WO Status	: Open
Main WO Number	:	Invoice State	: Not Invoiced
House Part Number	: RE-MACHINE.	Invoice Date	:
Description	:	Invoice Number	:
Manufactured	: No	Invoice Amount	: 0.00
Amount Req'd	: 0		
Amount Done	: 0	Order Entry No	:
Start Date	: 09-26-05	OE Value	: 0.00
Est Finish Date	:		
Act Finish Date	:	Est Margin	: 0.000%
Drawings Reqd	: No	Actual Margin	: 0.000%
Ok for Approval	:		
Approval Rec'd	:	$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
	==========	==========	=======		
Burden	: 0.00	0.00	0.00		
	==========	==========	=======		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

Dart Aerospace Ltd

W/O:		**WORK ORDER CHANGES**						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		**WORK ORDER NON-CONFORMANCE (NCR)**						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			
06.01.15	1	part pressed in A2804 hit by endmill.		Scrap: destroy	JD 06.01.15	_(signature)_ 06-01-16		_(signature)_ 06-01-16

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Bracket Assembly	**Part Number:**	**D2804-041**
Dwg: D2804 Rev. B	**Qty:**	
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler **Dwg not required**			
2	GA	Press D2805-1 into arm as per Dwg D2804 **Pick:** Qty Part Number Description Batch 1 D2804-1 Bracket _____ 1 D2805-1 Stop _____ 1 D2809 Bushing _____			
3	QC5	Inspect work to Step 2			
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3			
5	QC3	Inspect Powder Coat			
6	GA	Press D2809 into arm as per Dwg D2804			
7	GA	Spray LPS-3 on Bolt Shaft, **not** on thread as per Dwg D2804 **Pick:** Qty Part Number Description Batch 2 AN3C16A Bolt M17944 2 MS21043-3 Nut M14099 4 NAS1515H3 Washer M17944 A/R LPS-3 Corrosion Spray M17045	SAO	12.10.090	18
8	GA	Assemble as per Dwg D2804.	SO	06/01/24/10	
9	QC5	Inspect work to Step 8			
10	ST	Identify and Stock			
11	AC	 Cost / part: _____			
12	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

REFERENCE ONLY